

Work Order ID 105756

August-16-13 11:42:22 AM

105756

Page 1

Item ID: D3188-2M

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: SPACEPOD BODY RH

Start Date: 8/16/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 9/13/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 13-08-16

Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3188	Rev F
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100

0.00

100

PURCHASING

Purchasing

0.00

Purchasing

Memo

Issue P/O: 20980
Description: D3188-2MBODY
SHIP: QTY (8) D2213 Spacers
Supplier: Delastek
Conformity Certificate and Process sheet required
Ship 2 Items from Previous steps

CX 13/08/19 (1)

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

0.00

Packaging

Memo

Ensure a copy of certification of conformity and process sheet from Delastek is attached.

P 13/08/19 (1)

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
---	---	---

<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	
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Work Order ID 105756

August-16-13 11:42:23 AM

105756

Page 2

Item ID: D3188-2M Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: SPACEPOD BODY RH
 Start Date: 8/16/13 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 9/13/13 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control	Check for void spot and pins.								
130	Identify as per dwg & Stock Location: <u>composites</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

14-04-01 (Y)

14-04-01

(M) 14-04-01

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Picklist Print

Page 1

August-16-13 11:42:26 AM

Work Order ID: 105756

105756

Parent Item: D3188-2M

D3188-2M

Parent Item Name: SPACEPOD BODY RH

Start Date: 8/16/13

Required Date: 9/13/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New issue ecn882 06-11-30 EC
 IPP rev B rev D dwg 07.03.07 ec
 IPP rev C rev E dwg 07.04.16 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2213		Manufactured	No			100	Each	106.0000	8	8			
-------	--	--------------	----	--	--	-----	------	----------	---	---	--	--	--

D2213

Insert

**

C213/08/19

Location

Loc Qty

Loc Code

ST006

106

8

30809

106

D3188-2P

Purchased

No

110

Each

1.0000

1

1

D3188-2P

Spacepod Body

**

24 14-04-01

105756

Location

Loc Qty

Loc Code

CA

1

95145

1

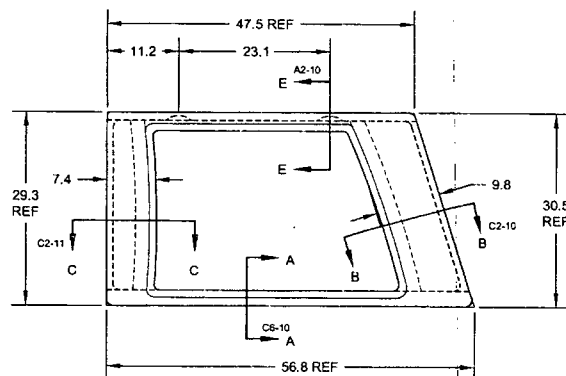
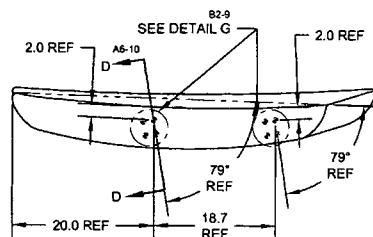
NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

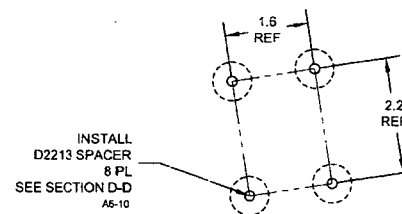
Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		



D3188-2M SPACEPOD BODY

D3188-2M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
- 2) SEE SHEET #10 FOR SECTION VIEWS.



DETAIL G D6-9

105756 MJS
13-08-16

RELEASED
2009-10-20

DESIGN	31	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.	RF	D3188	SHEET 9 OF 11
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	SPACEPOD BODY	NTS
DATE	09.07.13	COPYRIGHT © 2003 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMING OR COMMINGLED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



DELASTEK Inc.
2699 5e Avenue
Local 14,
Grand-Mère, Québec G9T 2P7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP

CERTIFICATE OF COMPLIANCE

Invoice No.	49734
Customer No.	DART US

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
05-11-2013	11-09-2013	23834	Chantal Lavoie	20980	Net 30 days USA
Ship Via		F.O.B.	Salesperson		GST/PST
FEDEX P1 Collect		Point de départ	Mathieu Doucet, ext.690		
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC134-0071	Line 3 N° D3188-2M, Spacepod Body RH U of M: Chaque Dwg. D3188 Rév.: F B105756 Serial # Lot # 55562 55562	

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

Mathieu Ayotte
Quality department



AQ-357


☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Lundi, 2013-09-16 13:45:17
 Utilisateur: Mario Chantia

Feuille de Procédé

4 / ASAP

Client :	DART US DART AEROSPACE	Nom Dessin :	SPACEPOD BODY RH
Numéro Job :	55562	Numéro Article :	DKC134-0071
Numéro :	3763	Numéro Dessin :	-
Numéro B.A. :		Projet Numéro :	DK-362
Cette fois :	2013-09-16 No. :	Révision dessin :	
Prsht Rev. :	NC	Matériel :	Fibre 7781 et résine 411-350
Prem. fois :	- - Type :	Date Dûe :	2013-09-16
Job précédente :	55561	Qté:	1 Ud UNITE

Écrit par : 
Vérifié & Approuvé par : _____
Commentaires : N° de dessin: D3188-2M rev. F

E.O.: N/A

Feuille de Procédé Rév.: 06 AMB0349 remplacé par
 AMB0511 (réf. RFC #226)

Formulaire d'inspection: N/A

Produit additionnel

Numéro Job:



# Séq.:	Machine ou	Description :
---------	------------	---------------

1.0	AAC1616	N° 83634, Frekote Loctite Wolo
-----	---------	--------------------------------

Comment Qty.: 0.050 UNITE(s)/Unit Total: 0.050 UNITE(s)
 N° 83634, Frekote Loctite Wolo N° de Lot: N/A

2.0	PRÉPARATION	Préparation du moule
-----	-------------	----------------------



Comment Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation du moule selon IF134-0020.

Date: 8/10/13 Sceau: 

3.0	AAC1885	Tissu à délaminer Release ply B
-----	---------	---------------------------------

Comment Qty.: 9.84 VERGE(s)/Unit Total: 9.84 VERGE(s)
 Tissu à délaminer Release ply B # de Lot: N/A

4.0	AAC1887	Wrighton 5200 Bleu P3
-----	---------	-----------------------

Comment Qty.: 9.27 VERGE(s)/Unit Total: 9.27 VERGE(s)
 Wrighton 5200 Bleu P3 # de Lot: N/A

5.0	AC0885	Feutre de drainage N° Airweave N 10
-----	--------	-------------------------------------

Comment Qty.: 6.00 VERGE(s)/Unit Total: 6.00 VERGE(s)

Date: Lundi, 2013-09-16 13:45:17

Utilisateur: Mario Chantal

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: SPACEPOD BODY RH

Numéro Job: 55562

Numéro DKC134-0071

Numéro Job:



Séq.:

Machine ou Opération:

Description :

6.0

AC0943

Stretchlon 200 poche à vide Vert

Comment Qty.: 7.00 VERGE(s)/Unit Total : 7.00 VERGE(s)

7.0

AMB0214

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Comment Qty.: 11.40 VERGE(s)/Unit Total : 11.40 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot:

1-41291-1

8.0

AMB0511

N° TG-13-U, Fiberglass 13 oz

Comment Qty.: 0.80 VERGE(s)/Unit Total : 0.80 VERGE(s)

N° TG-13-U, Fiberglass 13 oz

N° de Lot:

1-36302-1

9.0

AMB0213

WR1850 Roving 18oz x 50"

Comment Qty.: 0.350 KILOGRAMME(s)/Unit Total : 0.350 KILOGRAMME(s)

WR1850 Roving 18oz x 50"

N° de Lot:

1-35599-1

10.0

AC0886

Ruban à gommer jaune #. T/AT-200Y

Comment Qty.: 4.0000 ROULEAU(s)/Unit Total : 4.0000 ROULEAU(s)

11.0

PREP-GENERAL

Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Tailler les tissus selon IF134-0020.

Date: 7/10/13

Sceau:



12.0

AMB0286

Catalyst N° DDM-9

Comment Qty.: 0.0640 GALLON(s)/Unit Total : 0.0640 GALLON(s)

Catalyst N° DDM-9

N° de Lot:

1-27829-1

13.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 2.000 LITRE(s)/Unit Total : 2.000 LITRE(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot:

1-42702-1

14.0

AAC1540

Fibre de verre Miapoxy 66

Comment Qty.: 0.0040 GALLON(s)/Unit Total : 0.0040 GALLON(s)

Fibre de verre Miapoxy 66

N° de Lot:

1-40769-1

15.0

PREP-GENERAL

Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Laminer la 1ère coquille selon IF134-0020.

Date: 8/10/13










Sceau:

4460 R.L.












Date: Lundi, 2013-09-16 13:45:17
Utilisateur: Mario Chantal

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	SPACEPOD BODY RH
Numéro Job:	55562	Numéro	DKC134-0071
Numéro Job: 			
# Séq.:	Machine ou Opération:	Description :	
16.0	AMB0355	ATC core-cell A500 plain 4'x8' 1" thick	
Comment	Qty.: 0.750 FEUILLE(s)/Unit Total : 0.750 FEUILLE(s) ATC core-cell A500 plain 4'x8' 1" thick N° de Lot: <u>1-38256-1</u>		
17.0	TAILLAGE	Faire le taillage du matériel	
 			
Comment	Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs Tailler et ajuster les Foam Core selon IF134-0020. Date: <u>11-10-13</u> Sceau: <u>4460 RL</u>		
18.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Comment	Qty.: 0.136 KILOGRAMME(s)/Unit Total : 0.136 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-42702-1</u>		
19.0	AMB0286	Catalyst N° DDM-9	
Comment	Qty.: 0.0096 GALLON(s)/Unit Total : 0.0096 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>		
20.0	FINITION	Finition Générale	
 			
Comment	Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs Sceller les foam core selon IF134-0020. Date: <u>11-10-13</u> Sceau: <u>4460 RL</u>		
21.0	PERCAGE	Perçage de trous	
 			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Perçer les foam core selon IF134-0020. Date: <u>15-10-13</u> Sceau: <u>4460 RL</u>		
22.0	AAC1611	Polybond B46F	
Comment	Qty.: 0.078 KIT(s)/Unit Total : 0.078 KIT(s) Polybond B46F N° de Lot: <u>1-40597-1</u>		
23.0	ASSEMBLAGE	Assemblage mécanique	
 			
Comment	Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs Installer les foam core selon IF134-0020.		










Date: Lundi, 2013-09-16 13:45:17
Utilisateur: Mario Chantal

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	SPACEPOD BODY RH
Numéro Job:	55562	Numéro	DKC134-0071
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
	Date: <u>15/10/13</u> Sceau: <u>4460RL</u> 		
24.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler	
Comment	Qty.: 0.050 GALLON(s)/Unit Total : 0.050 GALLON(s) N° P-15-3, Adtech Micro Ultra Filler # de Lot: <u>1-41428-1</u>		
25.0	FINITION	Finition Générale	
			
Comment	Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs Usiner les foam core selon IF134-0020. Date: <u>16-10-13</u> Sceau: <u>4460RL</u>		
26.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Comment	Qty.: 1.600 KILOGRAMME(s)/Unit Total : 1.600 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-42702-1</u>		
27.0	AMB0286	Catalyst N° DDM-9	
Comment	Qty.: 0.0536 GALLON(s)/Unit Total : 0.0536 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>		
28.0	LAMINAGE	Faire le laminage	
			
Comment	Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs Laminer les plis de 9oz selon IF134-0020. Date: <u>17/10/13</u> Sceau: <u>4460RL</u> 		
29.0	TRIMAGE	Trimage	
			
Comment	Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs Faire le taillage selon IF134-0022. Date: <u>21-10-13</u> Sceau: <u>4460RL</u>		
30.0	AMB0286	Catalyst N° DDM-9	
Comment	Qty.: 0.0144 GALLON(s)/Unit Total : 0.0144 GALLON(s) Catalyst N° DDM-9 N° de Lot: _____		
31.0	AAC1540	Fibre de verre Miapoxy 66	
Comment	Qty.: 0.0420 GALLON(s)/Unit Total : 0.0420 GALLON(s) Fibre de verre Miapoxy 66 N° de Lot: _____		

Date: Lundi, 2013-09-16 13:45:17
Utilisateur: Mario Chantal

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	SPACEPOD BODY RH
Numéro Job:	55562	Numéro	DKC134-0071
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
32.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Comment	Qty.: 0.450 KILOGRAMME(s)/Unit Total: 0.450 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-40702-1</u>		
33.0	LAMINAGE	Faire le laminage	
			
Comment	Setup: 0.00Hrs/ Run: 55.0000Min Total Run : 0.9167Hrs Faire le laminage des derniers plis 9oz selon IF134-0020. Date: <u>21-10-13</u> Sceau: <u>4460RL</u>		
34.0	AAC1610	Spacer N° D2213	
Comment	Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s) Spacer N° D2213 N° de Lot: <u>1</u>		
35.0	ASSEMBLAGE	Assemblage mécanique	
			
Comment	Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs Faire l'assemblage des inserts selon IG 0097. Date: <u>22-10-13</u> Sceau: <u>4460RL</u>		
36.0	AAC1021	Dupont Primer N° 7704S	
Comment	Qty.: 0.5000 UNITE(s)/Unit Total: 0.5000 UNITE(s) Dupont Primer N° 7704S N° de Lot: <u>4460RL</u> <u>1-43178-2</u>		
37.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase	
Comment	Qty.: 0.0283 UNITE(s)/Unit Total: 0.0283 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: <u>2-40909-1</u>		
38.0	FINITION	Finition Générale	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Préparer la pièce selon IG 0008. Date: <u>1</u> Sceau: <u>24-10-13</u> <u>4460RL</u>		
39.0	PRIMER	Application primer	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Préparer et appliquer le primer selon IG 0008. Date: <u>24-10-13</u> Sceau: <u>20</u> # de fiche de mélange: <u>6488</u>		

Date: Lundi, 2013-09-16 13:45:17
Utilisateur: Mario Chantal

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 55562

Nom Dessin: SPACEPOD BODY RH
Numéro: DKC134-0071

Numéro Job:



Séq.:

Machine ou Opération:

Description :

40.0

AAC1492

N° P-15-3, Adtech Micro Ultra Filler

Comment Qty.: 0.010 GALLON(s)/Unit Total : 0.010 GALLON(s)
N° P-15-3, Adtech Micro Ultra Filler # de Lot: 1-43091-1

41.0

FINITION

Finition Générale



Comment Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs

Faire les réparations de finition s'il y a lieu selon IG 0008.

Date: 29/11/13

Sceau: 4460 R.L.



42.0

AAC1021

Dupont Primer N° 7704S

Comment Qty.: 0.5000 UNITE(s)/Unit Total : 0.5000 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-43178-2

43.0

AAC1101

N° 7775S, Dupont Activator - Reducer Chromabase

Comment Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-40909-1

44.0

PRIMER

Application primer



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Préparer et appliquer le primer selon IG 0008.

Date: 1/11/13

Sceau: 20



de fiche de mélange: 6493

45.0

INSPIC FINAL

Inspection finale



Comment Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'inspection générale de la pièce selon le dessin par le département de la qualité.

Date: 04/11/13

Sceau: 20



Initiales: JHA

46.0

EMBAL / ENTREPO

Emballage & Entreposage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'emballage selon IG 0057.

Date: 4/11/13

Sceau: 44516m